

Work Order ID 88689

\*88689\*

Page 1

July-30-12 2:33:40 PM

Item ID: D3650-5

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd Panel

Start Date: 7/30/12

Start Qty: 1.00

Cust Item ID:

Required Date: 7/31/12

Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *V*

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3650

*Rev C Custom*

100

0.00

\*100\*

FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3650

304.018"

Dwg Rev:

Prog Rev: *C Custom*

2-Deburr if necessary

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

120

0.00

\*120\*

QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

*Scrap 1208.72*  
*Trial Sit*

2

0

*Jm 12-7-31*

2

0

*Jm 12-7-31*



# Work Order ID 88689

**\*88689\***

Page 2

July-30-12 2:33:40 PM

Item ID: D3650-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fwd Panel  
 Start Date: 7/30/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 7/31/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Form as per Dwg D3650								
140		0.00							
<b>*140*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
<b>*150*</b>	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D3650								

**Work Order ID 88689****\*88689\***

Page 3

July-30-12 2:33:40 PM

Item ID: D3650-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Fwd Panel  
Start Date: 7/30/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
Required Date: 7/31/12 Req'd Qty: 1.00 **\*1\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

*mf*  
*12-08-22*

# Picklist Print

July-30-12 2:33:39 PM

Page 1

Work Order ID: 88689

Parent Item: D3650-5

Parent Item Name: Fwd Panel

Start Date: 7/30/12

Required Date: 7/31/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC  
 IPP Rev:B ECN 1113P 08-01-22 DD  
 IPP Rev:C ecn1162 08-04-02 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3650-7 Seal		Manufactured	No			150	Each	4.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		4							
				83521		4							
D3650-9 Angle		Manufactured	No			150	Each	2.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		2							
				69999		2							
D3893-1 DOUBLER		Manufactured	No				Each	8.0000		1			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		8							
				52689		8							
M304S26GA 304/316 0.018 SHEET		Purchased	No			150	sf	74.2500	0.813	0.8557895			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT020		74.25							
				117798		74.25				117798			
MS20427M3-3 Rivet		Purchased	No			150	Each	1,077.0000	8	8			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		1074							
				121114		1074							
				ST318		3							
				120930		3							

Jan 12-7-31

# Picklist Print

July-30-12 2:33:40 PM

Page 2

Work Order ID: 88689

Parent Item: D3650-5

Parent Item Name: Fwd Panel

Start Date: 7/30/12

Required Date: 7/31/12

Start Qty: 1.00

Required Qty: 1.00

MS21060-3K

Purchased

No

150

Each

111.0000

2

2

Nut Plate

Location

Loc Qty

Loc Code

ST302

111

116857

17

117423

13

117977

50

118267

31

MS21062-3K

Purchased

No

110

Each

102.0000

2

2

Nut Plate

Location

Loc Qty

Loc Code

317

50

122452

50

ST302

52

109590

4

117343

48

NAS9307/M-4-03

Purchased

No

150

Each

223.0000

12

12

RIVET

Location

Loc Qty

Loc Code

ST280

223

109545

135

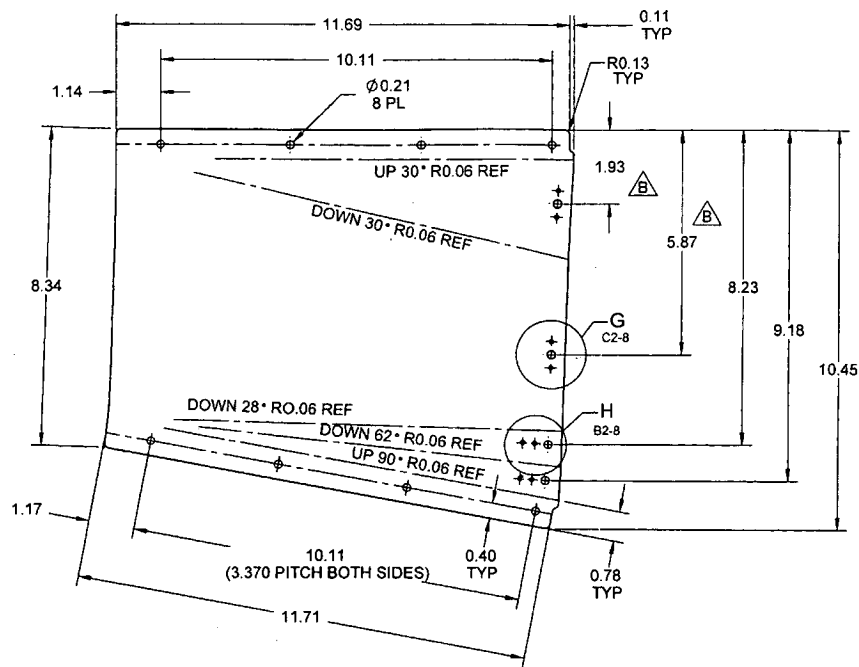
117979

88

July-30-12 2:33:40 PM

Shop Packet Print

Page 2

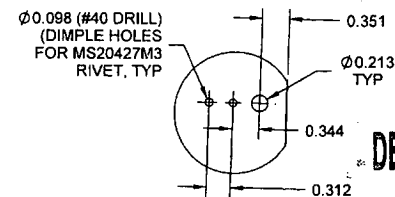
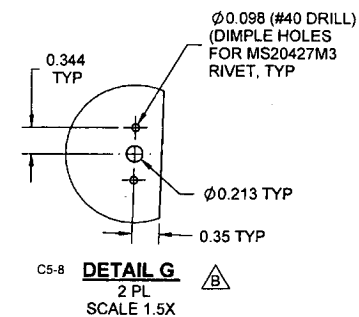
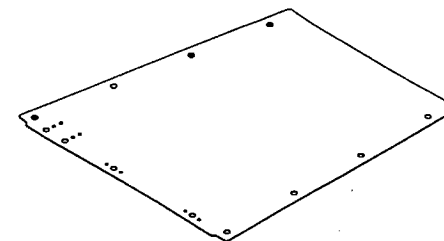


**D3650-5F FLAT PATTERN**

**NOTES:**





- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 THICK (26 GAUGE) SHEET, PER MIL-S-5059 OR AMS 5513/5524 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.6 lb

**UNDER REVIEW**  
*[Signature]*  
 OK 4/24/14



**DEO ATTACHED**

**RELEASED**  
 08/11/17

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3650</b>	REV. C
MFG. APPR.		SHEET 8 OF 9	
APPROVED		TITLE	SCALE
DE APPR.		<b>TOP PANEL ASSEMBLY</b>	NTS
DATE	<b>08.10.14</b>	<small><b>COPYRIGHT © 2007 BY DART AEROSPACE LTD</b> THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD		Work Order:	
Description: Fwd Panel <i>E</i>		Part Number: D3650-5 <i>Custom</i>	
Inspection Dwg: D3650	Rev: <i>B C Custom</i>	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.100"	✓		✓	mmoi
Ø0.213 <i>x0.275</i>	+0.005/-0.001	0.216" <i>x0.274</i>			✓	"
0.40	+/-0.030	0.214"	✓		✓	"
1.17	+/-0.030	1.184"	✓		✓	"
11.71	+/-0.030	11.711"	✓		✓	Producer
10.11 <i>pitch</i>	+/-0.030	10.117"	✓		✓	"
5.87	+/-0.030	5.870"	✓		✓	mmoi
1.93	+/-0.030	1.935"	✓		✓	"
8.23	+/-0.030	8.239"	✓		✓	Producer
9.18	+/-0.030	<del>8.239"</del>				
10.45	+/-0.030	10.436"	✓		✓	Producer
11.69	+/-0.030	11.702"	✓		✓	"
1.14	+/-0.030	1.142"	✓			mmoi
8.34	+/-0.030	8.353"	✓		✓	Producer
0.018"	+/-0.010"	0.018"	✓		✓	mmoi

Measured by: <i>Jm</i>	Audited by: <i>Smb</i>	Prototype Approval:	N/A
Date: <i>12-7-31</i>	Date: <i>12-7-31</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD <i>df</i>	<i>DA</i>